

**Work Order ID 70534**

Friday, June 10, 2011 2:54:05 PM



Page 1

Item ID: D205-770-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Engine Mount

Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-06-03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

IIN D205-770

Rev C

MDL-D205-770

E

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D205-770-011 CHG003

8/11/07

ck for ch 11/07/06

110

0.00



Packaging

Packaging

Pick Kit

Memo

11/7/07

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 70534**

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Page 2

Item ID: D205-770-011

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Setup Start



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Item Name: Replacement Engine Mount

Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID    | Operation<br>Description   | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|-----------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120<br><br>QC<br>Quality Control  | QC4- 100% Inspect kits for completeness<br><br>Memo  | 0.00<br><br>0.00     |         |        |              | (1)           |               |                  |                |
| 130<br><br>Packaging<br>Packaging | Packaging<br><br>Memo<br>Identify and pack for shipping as per PPP D205-770-011 CHG003<br>Location: <u>13C</u><br>PPP Rev: _____ | 0.00<br><br>0.00     |         |        |              | LO 11/7/08    |               |                  |                |
| 140<br><br>QC<br>Quality Control  | QC21- Final Inspection - Work Order Release<br><br>Memo  | 0.00<br><br>0.00     |         |        |              | CK 11/07/08   |               |                  |                |

MF 11-07-07

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Friday, June 10, 2011 2:54:11 PM

Page 1

Work Order ID: 70534

Parent Item: D205-770-011

Parent Item Name: Replacement Engine Mount

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue ECN1165p 08-03-31 DD verified by:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3684-043<br>MOUNT ASSEMBLY     |                        | Manufactured  | No          |                     |                  | 110             | Each               | 0.0000         | 1           | 1            |               |                |        |
| D3684-045<br>LEG ASSEMBLY       |                        | Manufactured  | No          |                     |                  | 110             | Each               | 0.0000         | 1           | 1            |               |                |        |
| D3692-1<br>SPACER               |                        | Manufactured  | No          |                     |                  | 110             | Each               | 213.0000       | 4           | 4            |               |                |        |

## Location

## Loc Qty

## Loc Code

ST075

213

51467

213

AN3C12A

Purchased

No

110

Each

40.0000

4

Bolts

## Location

## Loc Qty

## Loc Code

ST351

40

116924

6

117514

4

117794

30

MS21043-3

Purchased

No

110

Each

383.0000

2

Nut

## Location

## Loc Qty

## Loc Code

FG

80

103691

80

ST301

303

112314

303

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Friday, June 10, 2011 2:54:11 PM

Page 2

Work Order ID: 70534

Parent Item: D205-770-011

Parent Item Name: Replacement Engine Mount



Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

S D3685-041

Manufactured No

110

Each

0.0000

1

1



BIPOD MOUNT ASSEMBLY



B67925 SP

S D3686-041

Manufactured No

110

Each

0.0000

1

1



MONOPOD ASSEMBLY



~~B67925~~ 11/7/08  
B67923

Friday, June 10, 2011 2:54:11 PM

Shop Packet Print

Page 2

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D205-770

Page 10 of 11

#### 4. WEIGHT AND BALANCE

The following is the net weight increase associated with the D205-770-011 Kit.

| Installation                 | Weight  | LATERAL |             | LONGITUDINAL |            |
|------------------------------|---------|---------|-------------|--------------|------------|
|                              |         | Arm     | Moment      | Arm          | Moment     |
| D205-770-011                 | 14.6 lb | -3.5 in | -51.1 in-lb | 107.8 in     | 1574 in-lb |
| Replacement Engine Mount Kit | 6.62 kg | -0.09 m | -0.6 m-kg   | 2.74 m       | 18.1 m-kg  |

#### 5. PARTS LIST

| Qty<br>-011 | Part Number    | Description                  |
|-------------|----------------|------------------------------|
| X           | D205-770-011   | REPLACEMENT ENGINE MOUNT KIT |
| 1           | D3684-041      | TRIPOD MOUNT ASSEMBLY        |
| 1           | *D3684-043     | MOUNT ASSEMBLY               |
| 8           | **D3692-1      | SPACER                       |
| 4           | **AN3C-12A     | BOLT                         |
| 4           | **MS21043-3    | NUT                          |
| 1           | **D3687-1      | MOUNT                        |
| 1           | **D3684-047    | FWD LEG ASSEMBLY             |
| 1           | ***D3688-1     | STUD                         |
| 1           | ***D3689-1     | SLEEVE                       |
| 1           | ***D3691-1     | STUD                         |
| 4           | ***D3692-1     | SPACER                       |
| 1           | ***D3693-1     | ROD END BEARING              |
| 2           | ***AN3C-12A    | BOLT                         |
| 2           | ***MS21043-3   | NUT                          |
| 1           | ***NAS509-12C  | NUT                          |
| 1           | ***NAS509L-12C | NUT                          |
| 1           | **D3684-049    | AFT LEG ASSEMBLY             |
| 1           | ***D3688-3     | STUD                         |
| 1           | ***D3689-1     | SLEEVE                       |
| 1           | ***D3691-1     | STUD                         |
| 4           | ***D3692-1     | SPACER                       |
| 1           | ***D3693-1     | ROD END BEARING              |
| 2           | ***AN3C-12A    | BOLT                         |
| 2           | ***MS21043-3   | NUT                          |
| 1           | ***NAS509-12C  | NUT                          |
| 1           | ***NAS509L-12C | NUT                          |
| 1           | *D3684-045     | INBOARD LEG ASSEMBLY         |
| 1           | **D3688-5      | STUD                         |
| 1           | **D3689-1      | SLEEVE                       |
| 1           | **D3691-1      | STUD                         |
| 4           | **D3692-1      | SPACER                       |
| 1           | **D3693-1      | ROD END BEARING              |
| 2           | **AN3C-12A     | BOLT                         |
| 2           | **MS21043-3    | NUT                          |
| 1           | **NAS509-12C   | NUT                          |
| 1           | **NAS509L-12C  | NUT                          |
| 4           | *D3692-1       | SPACER                       |
| 2           | *AN3C-12A      | BOLT                         |
| 2           | *MS21043-3     | NUT                          |

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Revision: C

Date: 10.05.20

continued from previous page...

| Qty<br>-011 | Part Number      | Description                 |
|-------------|------------------|-----------------------------|
| <b>1</b>    | <b>D3685-041</b> | <b>BIPOD MOUNT ASSEMBLY</b> |
| 1           | *D3687-3         | MOUNT                       |
| 1           | *D3684-047       | FWD LEG ASSEMBLY            |
| 1           | **D3688-1        | STUD                        |
| 1           | **D3689-1        | SLEEVE                      |
| 1           | **D3691-1        | STUD                        |
| 4           | **D3692-1        | SPACER                      |
| 1           | **D3693-1        | ROD END BEARING             |
| 2           | **AN3C-12A       | BOLT                        |
| 2           | **MS21043-3      | NUT                         |
| 1           | **NAS509-12C     | NUT                         |
| 1           | **NAS509L-12C    | NUT                         |
| 1           | *D3684-049       | AFT LEG ASSEMBLY            |
| 1           | **D3688-3        | STUD                        |
| 1           | **D3689-1        | SLEEVE                      |
| 1           | **D3691-1        | STUD                        |
| 4           | **D3692-1        | SPACER                      |
| 1           | **D3693-1        | ROD END BEARING             |
| 2           | **AN3C-12A       | BOLT                        |
| 2           | **MS21043-3      | NUT                         |
| 1           | **NAS509-12C     | NUT                         |
| 1           | **NAS509L-12C    | NUT                         |
| 8           | *D3692-1         | SPACER                      |
| 4           | *AN3C-12A        | BOLT                        |
| 4           | *MS21043-3       | NUT                         |
| <b>1</b>    | <b>D3686-041</b> | <b>MONOPOD ASSEMBLY</b>     |
| 1           | *D3688-7         | STUD                        |
| 1           | *D3689-1         | SLEEVE                      |
| 1           | *D3691-1         | STUD                        |
| 4           | *D3692-1         | SPACER                      |
| 4           | *D3692-3         | SPACER                      |
| 1           | *D3693-1         | ROD END BEARING             |
| 1           | *D3693-3         | ROD END BEARING             |
| 2           | *AN3C-10A        | BOLT                        |
| 2           | *AN3C-12A        | BOLT                        |
| 4           | *MS21043-3       | NUT                         |
| 1           | *NAS509-12C      | NUT                         |
| 1           | *NAS509L-12C     | NUT                         |

(NOTE: PARTS IN BOLD TYPE CONSTITUTE PICK LIST FOR D205-770-011 KIT)

\* PART IS INCLUDED WITH ASSEMBLY ABOVE

\*\* PART IS INCLUDED WITH ASSEMBLY ABOVE

\*\*\* PART IS INCLUDED WITH ASSEMBLY ABOVE